

Date: Wednesday, 2/20/2008 4:21:14 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	LOW PROFILE BASKET LID ASS'Y		
Job Number	37526			Part Number	D3713042		
Estimate Number	13153			Drawing Number	D3713 U/R		
P.O. Number				Project Number	N/A		
This Issue	2/20/2008	S.O. No.		Drawing Revision	U/R		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	LARGE FAB ASSY	Due Date	3/10/2008		
Previous Run	37287			Qty:	1	Um:	Each
Written By	<u>[Signature]</u>						
Checked & Approved By	<u>[Signature]</u>						
Comment	Est Rev:A new issue 08-01-30 DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :																					
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W																					
Comment: Qty.: 32.5731 f(s)/Unit Total : 32.5731 f(s) 304 SQ Tube.75x.75x.065W																							
1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.																							
<table> <thead> <tr> <th>QTY</th> <th>PART NUMBER</th> <th>BATCH</th> <th></th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D3714-1</td> <td><u>M106199</u></td> <td></td> </tr> <tr> <td>2</td> <td>D3715-1</td> <td><u>M106199</u></td> <td></td> </tr> <tr> <td>10</td> <td>D3716-1</td> <td><u>M106199</u></td> <td></td> </tr> <tr> <td>4</td> <td>D3732-1</td> <td><u>M106199</u> ✓</td> <td></td> </tr> </tbody> </table> <p><i>PL 08-03-13</i></p>				QTY	PART NUMBER	BATCH		2	D3714-1	<u>M106199</u>		2	D3715-1	<u>M106199</u>		10	D3716-1	<u>M106199</u>		4	D3732-1	<u>M106199</u> ✓	
QTY	PART NUMBER	BATCH																					
2	D3714-1	<u>M106199</u>																					
2	D3715-1	<u>M106199</u>																					
10	D3716-1	<u>M106199</u>																					
4	D3732-1	<u>M106199</u> ✓																					
2- Deburr																							
2.0	D23271	Spacer Bushing																					
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Spacer Bushing batch <u>B31693</u> ✓																							
<p><i>PL 08-03-13</i></p>																							
3.0	D2581	Mounting Bracket																					
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mounting Bracket batch <u>B36481</u> ✓																							
<p><i>PL 08-03-13</i></p>																							
4.0	D37491	HINGE HALF																					
Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) HINGE HALF batch <u>B37202</u> ✓																							
<p><i>PL 08-03-13</i></p>																							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:21:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: LOW PROFILE BASKET LID ASS'Y
Job Number: 37526		Part Number: D3713042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	D2329	Label Plate 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Label Plate batch <u>335686</u> ✓		 <i>PCL 08-03-13</i>
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1 1- drill holes in both D3715-1 as per dwg D3715 2- deburr 3- assemble as per dwg D3713 and weld as per QSI004		 <i>PCL 08-03-13</i>
7.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		 <i>PD 08-03-14</i>
8.0	QC5	INSPECT WORK TO CURRENT STEP  ENGINEERING APPROVAL <i>ASS 08-03-13</i>
Comment: INSPECT WORK TO CURRENT STEP		
9.0	M304EX07516F	Expanded Metal Flat Slab 
Comment: Qty.: 17.8500 sf(s)/Unit Total : 17.8500 sf(s) Expanded Metal Flat Stainless Steel Pick: Qty Part Number Description Batch 17sq.ft M304EX0.75-16F Expanded Metal <u>m106798✓</u>		 <i>PBL 08-03-17</i>
10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1 1- cut mesh as per dwg D3743 2- weld mesh as per dwg D3713		<i>PCL 08-03-11</i> <i>PCL 08-03-13</i> <i>PCL 08-03-13</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:21:14 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 37526

Part Number: D3713042

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC5



ASS

INSPECT WORK TO CURRENT STEP
ENGINEERING
APPROVAL



06.03.14

8.03.14 (4)

Comment: INSPECT WORK TO CURRENT STEP

12.0 QC9



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

13.0 POWDER COATING

POWDER COATING



M100700



(1X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m-1 08/03/14

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(1)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



M107385



(1).

Comment: Wing Walk as per Dwg D3713 and QSI 005 4.4



BL 08-03-14

16.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(1)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

08-03-15

17.0 PACKAGING 1

PACKAGING RESOURCE #1



(1)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GIA.

MF

08-03-15

18.0 QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/17

Job Completion



POSITIVE RECALL
EFFECTIVE 08/02/11 AUTH 11
RELEASED 11 DATE 08/03/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

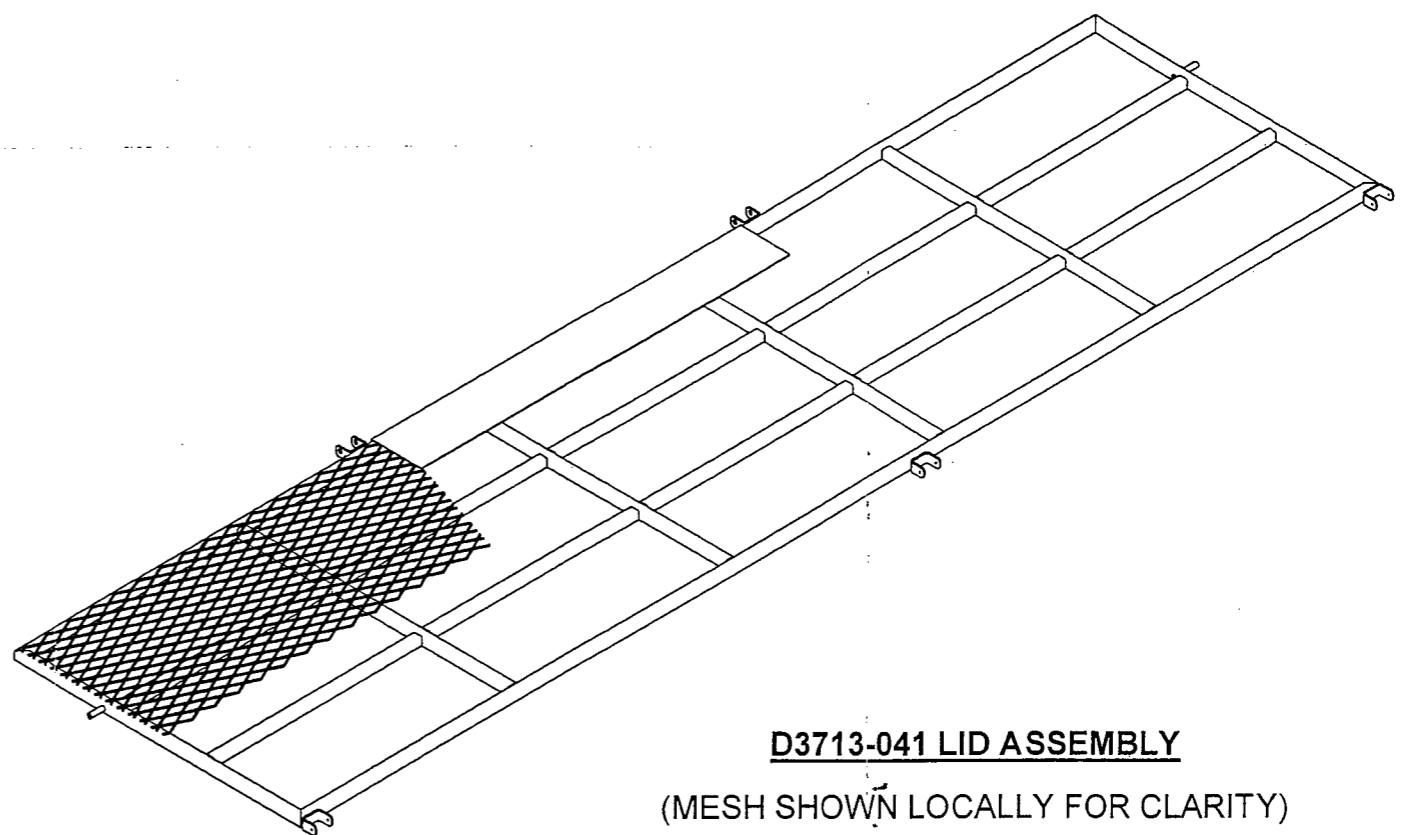
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 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY.	PART NUMBER	DESCRIPTION
X	D3713-041	LID ASSY LOW PROFILE BASKET
2	D2327-1	SPACER
1	D2329	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3714-1	RIB
2	D3715-1	RIB
10	D3716-1	RIB
4	D3732-1	RIB
1	D3743-1	MESH
3	D3749-1	HINGE HALF

**D3713-041 LID ASSEMBLY**

(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37506

PRELIMINARY ISSUE

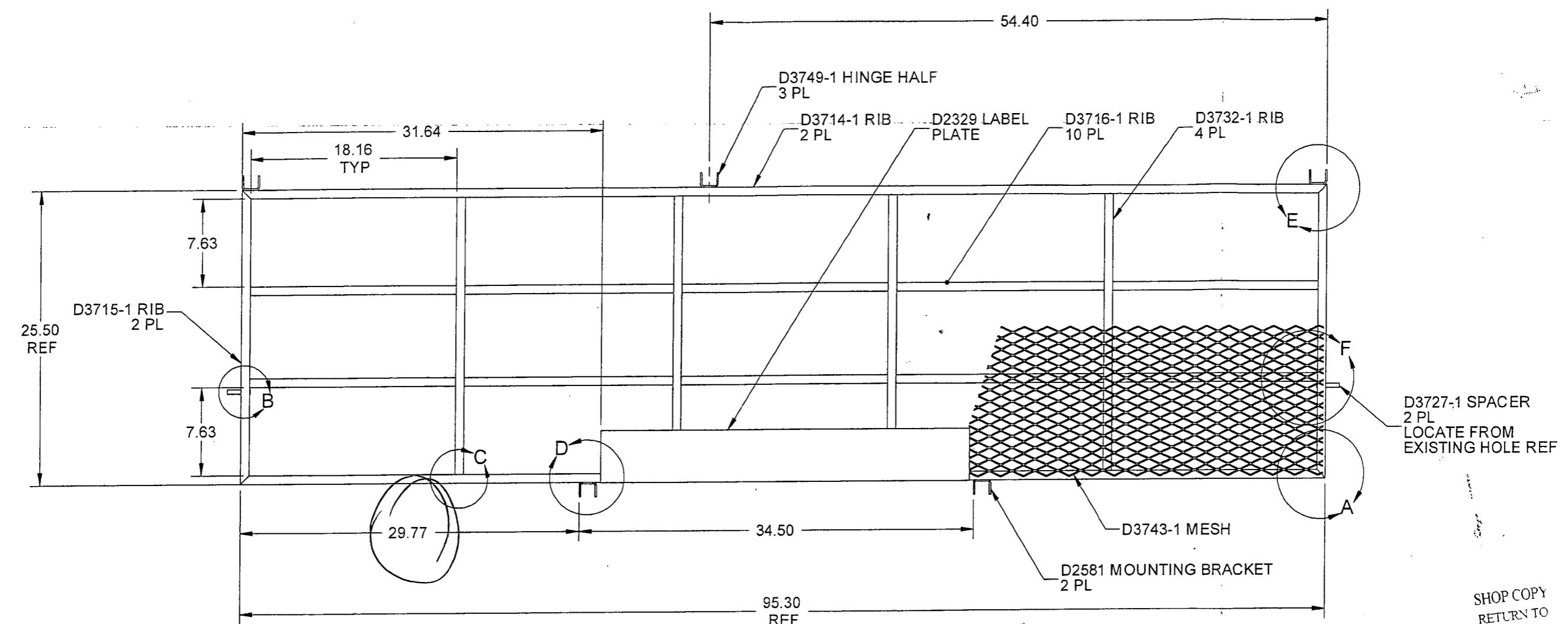
LE 08.02.15

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 36 lbs APPROX.
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.		D3713	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.	#	LID ASSEMBLY	NTS
DATE	08.02.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



D3713-041 LID ASSEMBLY

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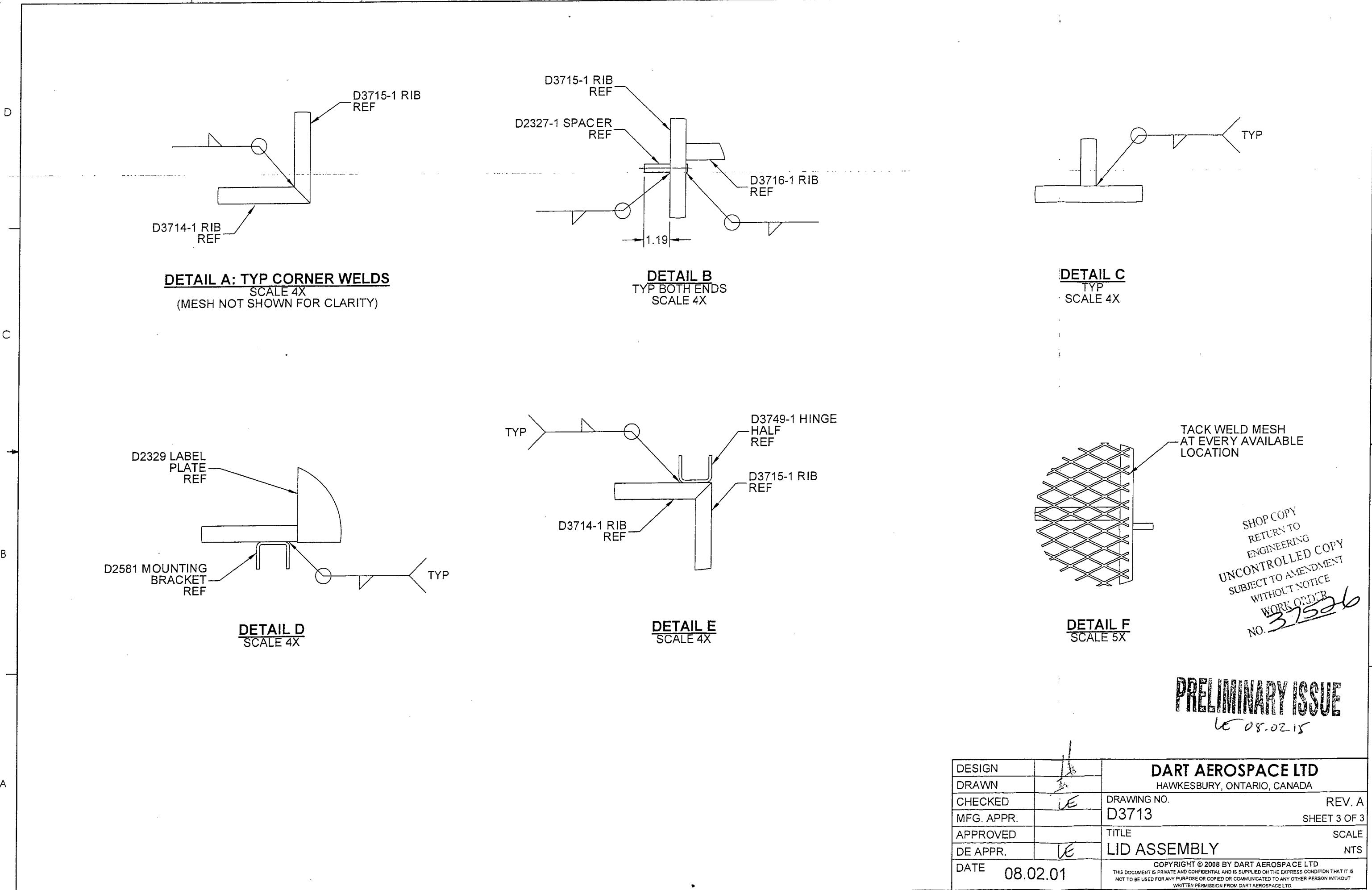
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WITHOUT NOTICE
WORK ORDER
NO. 37526

PRELIMINARY ISSUE

LE 08.02.15

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	LE	DRAWING NO.
MFG. APPR.		D3713
APPROVED		REV. A
DE APPR.	III	SHEET 2 OF 3
DATE	08.02.01	SCALE
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		LID ASSEMBLY
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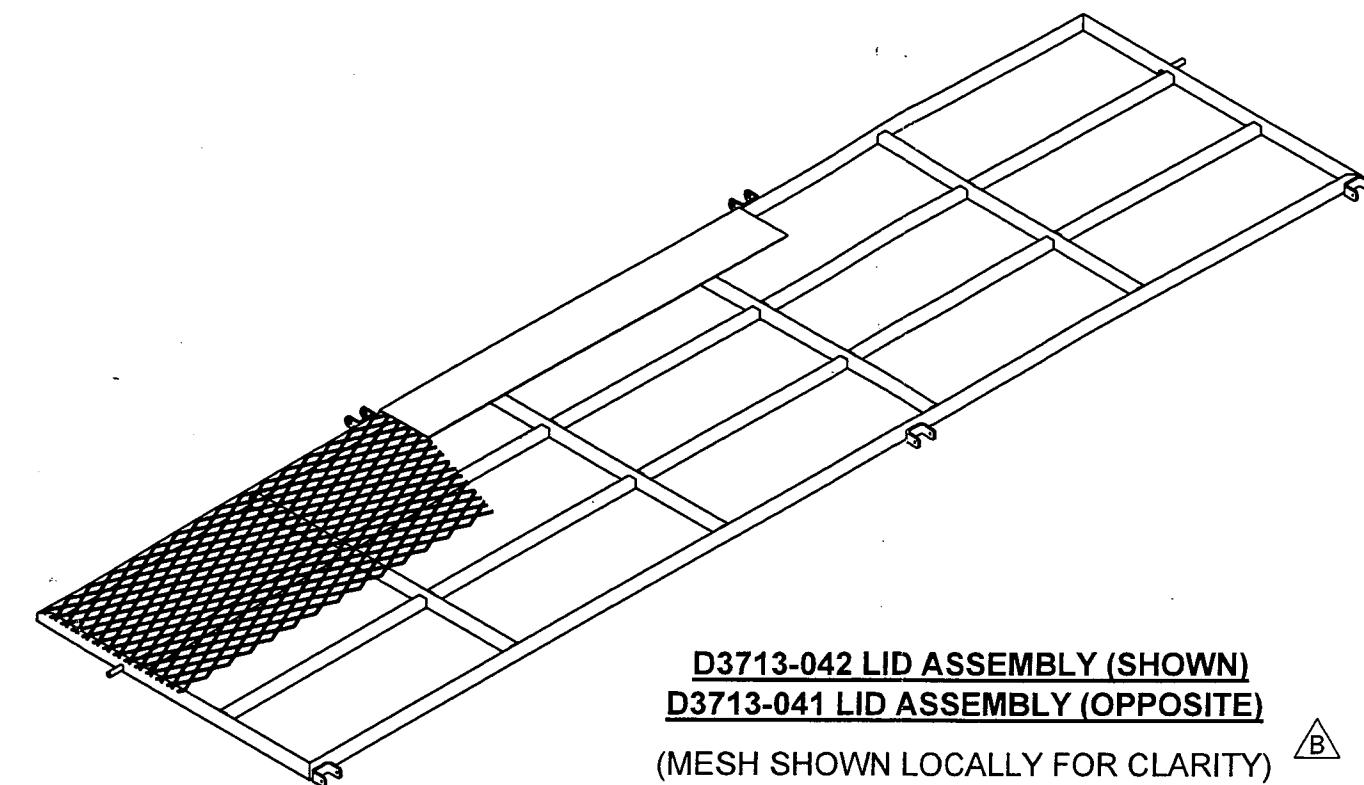
8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

D

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
	X	D3713-042	LID ASSEMBLY
2	2	D2327-1	SPACER
1	1	D2329	LABEL PLATE
2	2	D2581	MOUNTING BRACKET
2	2	D3714-1	RIB
2	2	D3715-1	RIB
10	10	D3716-1	RIB
4	4	D3732-1	RIB
1	1	D3743-1	MESH
3	3	D3749-1	HINGE HALF



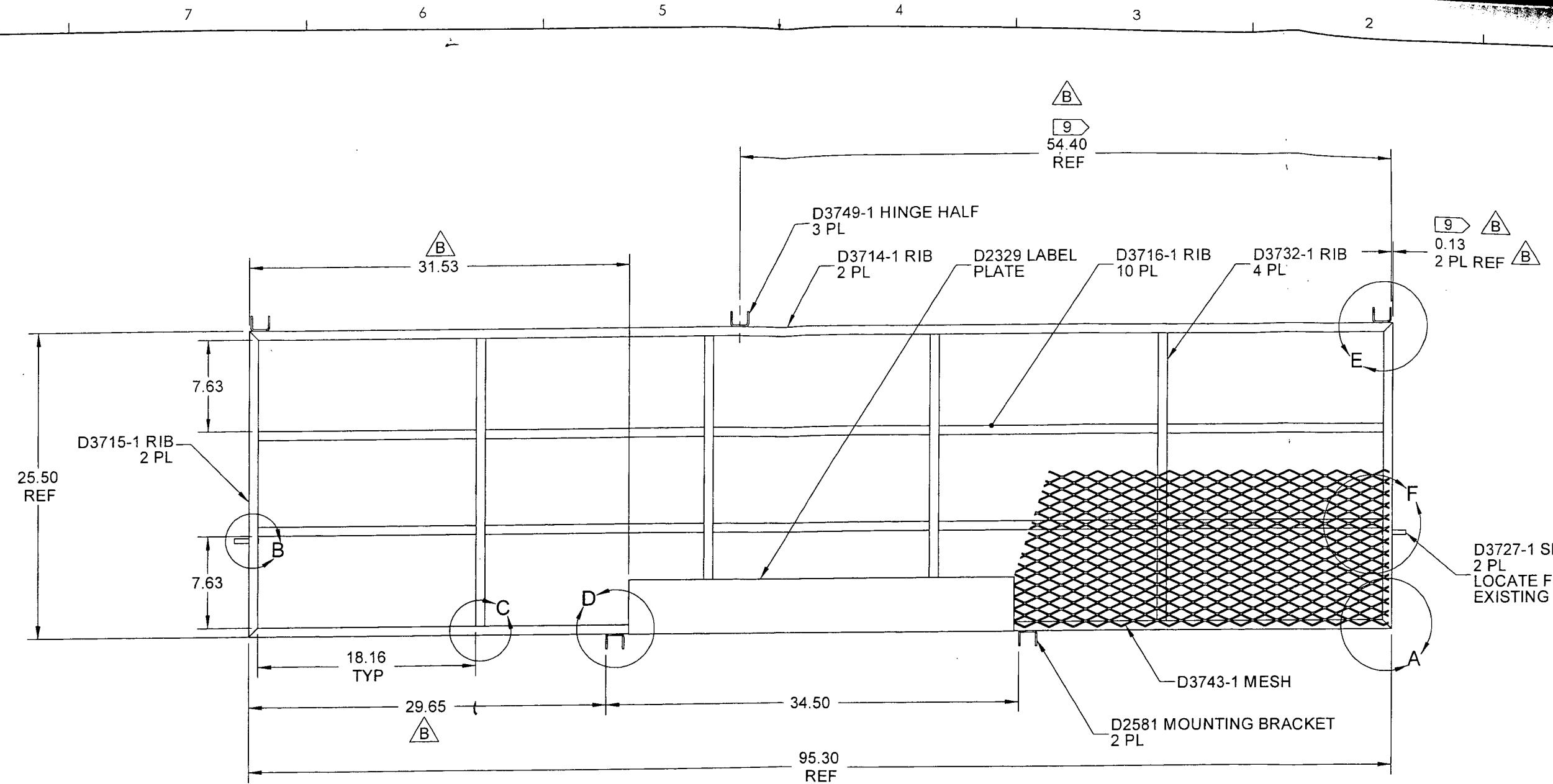
D3713-042 LID ASSEMBLY (SHOWN)
D3713-041 LID ASSEMBLY (OPPOSITE)

(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY

B	SHEET 1 -042 WAS -041; ADDED CORRECT -041 ASSEMBLY, NOTE 9 ADDED, ZONE C2 LID ASSEMBLY WAS D3713-041. WEIGHT WAS 36 lbs. SHEET 2 ZONE B5 LID ASSEMBLY WAS D3713-041, ZONE D6 31.53 DIM WAS 31.64, ZONE D3 54.40 DIM NOW REF ZONE D2 0.13 REF DIM ADDED ZONE B6 29.65 DIM WAS 29.77, ZONE D3 & D2 FLAG NOTE 9 ADDED.			AJS	08.02.27
A	NEW ISSUE			AJS	08.02.01
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED	<i>CE</i>				
MFG. APPR.	<i>DA</i>				
APPROVED	<i>MO</i>				
DE APPR.	<i>TH</i>				
DATE	08.02.27			SCALE	NTS
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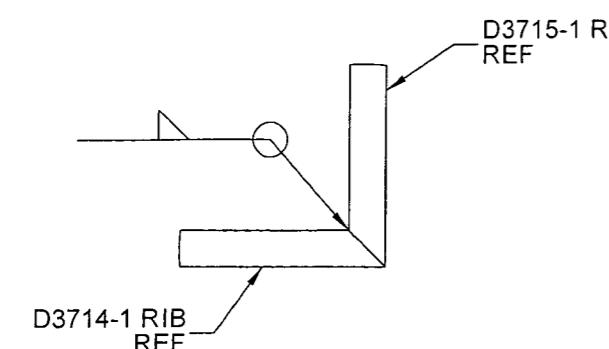
D3713-042 LID ASSEMBLY (SHOWN) ▲
D3713-041 LID ASSEMBLY (OPPOSITE)

(MESH SHOWN LOCALLY FOR CLARITY)

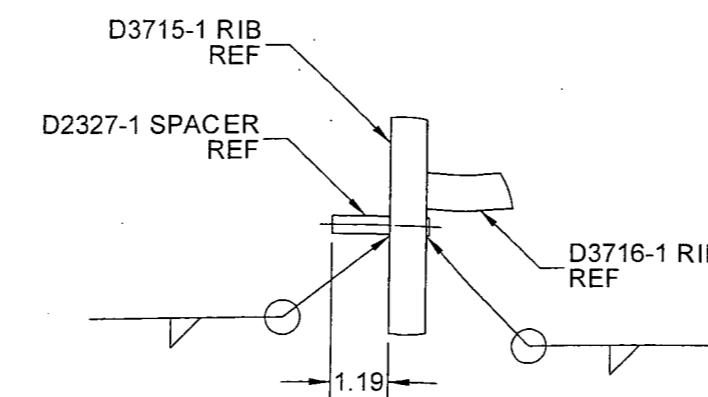
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MFG. APPR.	MD	REV. B
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8 7 6 5 4 3 2

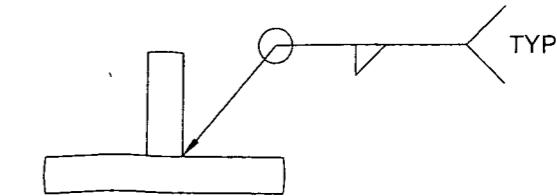
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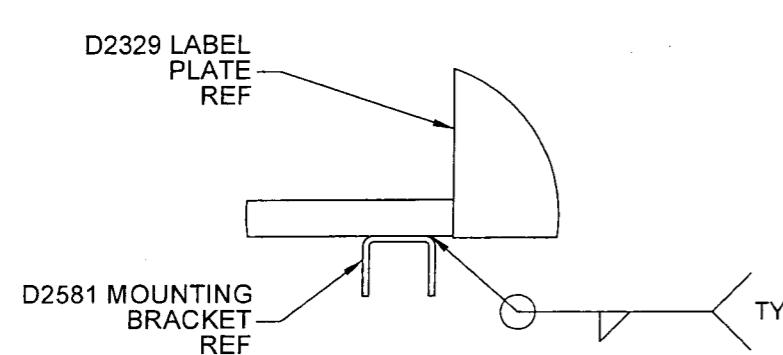
DETAIL A: TYP CORNER WELDS
SCALE 4X
(MESH NOT SHOWN FOR CLARITY)



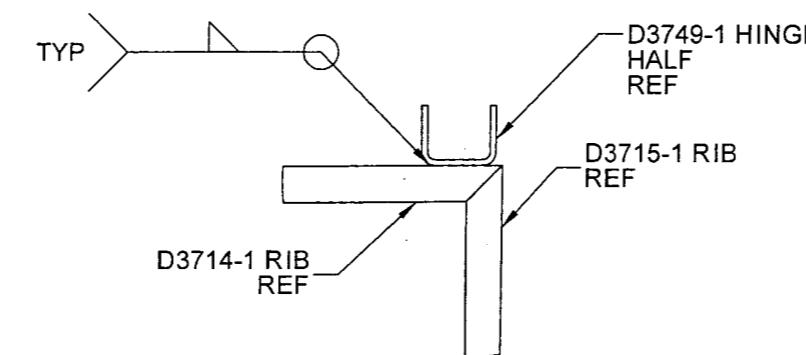
DETAIL B
TYP BOTH ENDS
SCALE 4X



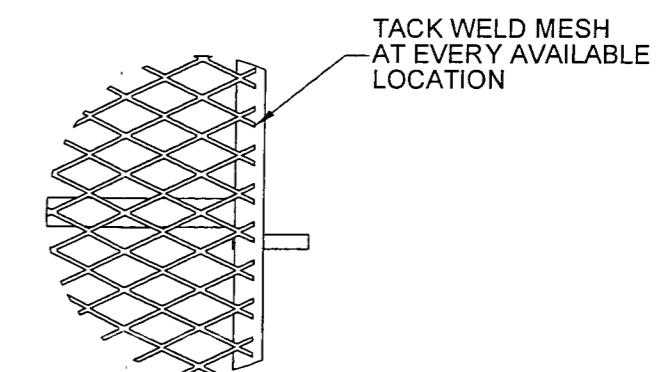
DETAIL C
TYP
SCALE 4X



DETAIL D
SCALE 4X



DETAIL E
SCALE 4X



DETAIL F
SCALE 5X

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